

Date: Tuesday, 4/17/2007 3:46:00 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LITTER TIE DOWN ASS'Y
Job Number : 31883	
Estimate Number : 10360	
P.O. Number : <i>NIA</i>	Part Number : D2350
This Issue : 4/17/2007 S.O. No. : <i>NIA</i>	Drawing Number : D2350 / D2363
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>NIA</i> Type : MACHINED PARTS	Drawing Revision : B/E
Previous Run : 29135	Material : <i>NIA</i>
Written By : _____	Due Date : 5/2/2007 Qty: 4 Um: Each
Checked & Approved By : <i>2/10/07.04.18</i>	
Comment : est rev B 06.05.17 added ass'y EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6201	T Extrusion 4X4X3/8
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Comment: Qty.: 1.0631 f(s)/Unit Total : 4.2525 f(s)

Material: D6201 (6061-T6 (QQ-A-200/8) 4" x 4" x 3/8" Thick 'T' extrusion

229367

Batch:

J.L 07/05/18

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blanks: 12.150" long

J.L 07/05/18

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio D2363 and Dwg D2363

J.L 07/05/18

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 07/05/18

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

36 07/05/18

6.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Tumble & deburr

J.L 07/05/22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval - Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/29
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.05.18	3	DIM 1.700 IS 1.685	J.L. 07/05/18	THIS DEVIATION IS ACCEPTABLE.	J.L. 07/05/18	J.L. 07/05-22	J.L. 07-05-18	J.L. 07/05-22
07/05/18	3	- 1 part is scrapped, origin in folio was not properly indicated.	J.L. 07/05/18	- scrap + replace. update folio	J.L. 07/05/18	J.L. 07/05-22	J.L. 07/05-22	J.L. 07/05-22

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:46:01 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y

Job Number: 31883

Part Number: D2350

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



2005-22 (4)



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FA/SR

07/05/24 (4)

POSITIVE
RECALL

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

07-05-25 (4)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



7/5/28 SA



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

D2372

Quick Release



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2372 Fastener

129147

12.0

D2444

Pip Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2444 Pip Pin

128894

13.0

AN960JD10L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

3 AN960JD10L Washer

M103044

7/5/28 SA

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
070522	8.0	Finish was not updated on the Dwg from Anodize → Alodine: Powdercoat. Do not complete past step, 17.0, until engineering approval. Positive Recall	J	070822	4	J 070522	J 070522

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: Date: 07/05/29
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:46:01 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y

Job Number: 31883

Part Number: D2350

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

MS21042L3

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 MS21042L3 Nut (or -3)

4103691

15.0

MS27039113

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS27039-1-13 Screw

413719 7/5/28 SQ

16.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2350

mul 07/05/28

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JAOS 29 (4)

POSITIVE
RECALL

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

EP 07/05/29 (4)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/29 (4)

Job Completion



W Dros 29

POSITIVE RECALL

EFFECTIVE *JAOS 22 AUTH U*

RELEASED *7* DATE *07/05/29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

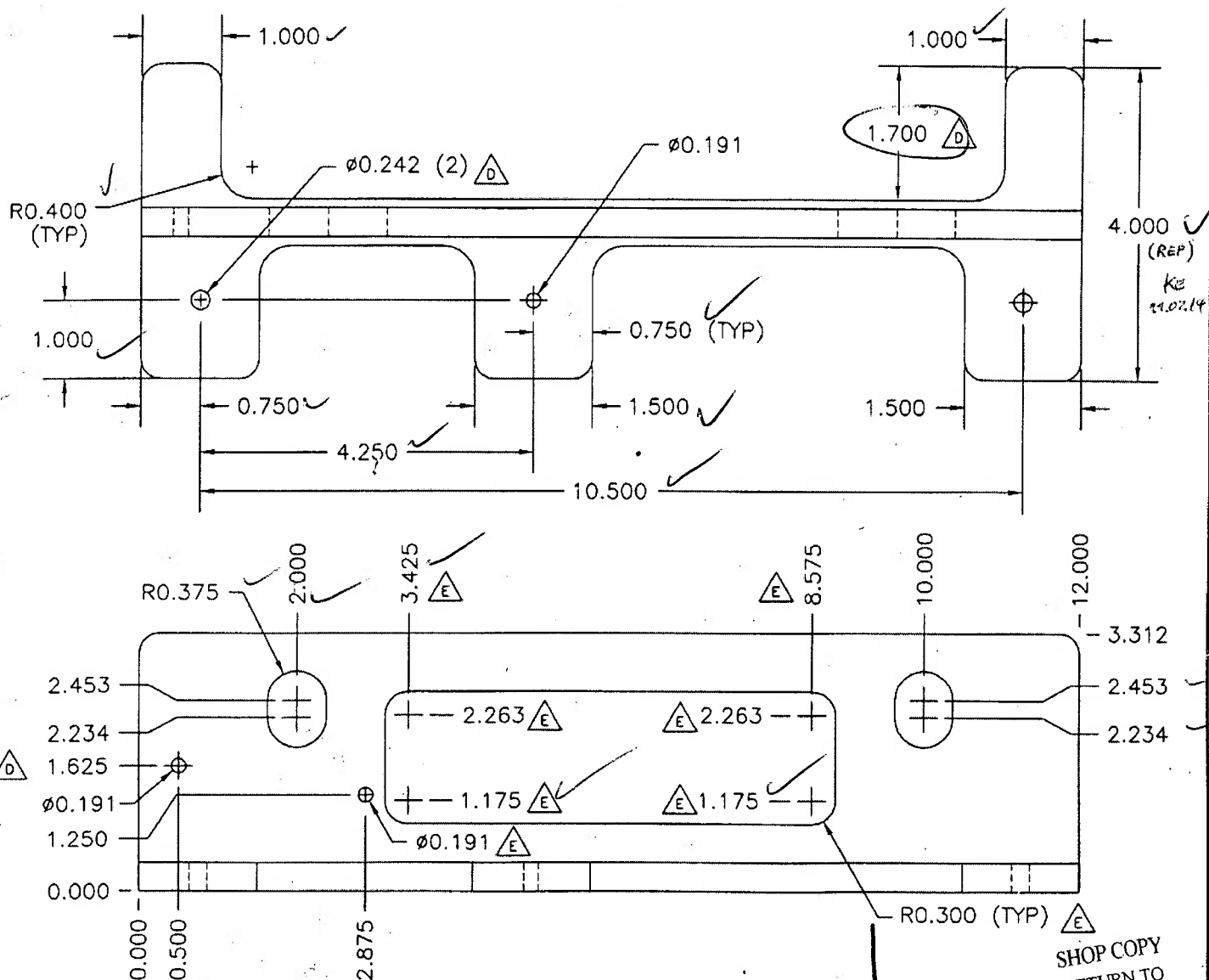
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED DIOY	APPROVED BW	DRAWING NO. D2363	REV. E SHEET 1 OF 1
DATE 97.10.01		TITLE LITTER TIE DOWN BRACKET	SCALE 1:2
A	95.01.14	NEW ISSUE	
B	95.02.14	MODIFIED HOLES	
C	95.03.06	0.191 WAS 0.197	
D	95.03.06	CHANGES TO DIMENSIONS	
E	97.10.01	CHANGES FOR MACHINING	

RELEASED
971003 KE
TSR 4129



MATERIAL: 6061-T6 (QQ-A-200/8) 4X4X3/8" T SECTION
FINISH: ANODIZE Alodine Per Q51005 4.1
207.05.29
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
31883



DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED <i>[Signature]</i>	DRAWING NO. D2350	REV. B SHEET 1 OF 2
DATE 95:02:20		TITLE LITTER TIE DOWN ASSEMBLY	

RELEASED
960607

D2350	Part No.	Description
X	D2350	LITTER TIE DOWN ASSEMBLY (NON-LOCKING)
1	D2363	LITTER TIE DOWN (NON-LOCKING)
2	D2372	QUICK RELEASE FASTENER
1	D2444	PIP PIN
1	AD960JD10 L	WASHER
1	MS21042LB	NUT
1	MS27039-A-13	SCREW

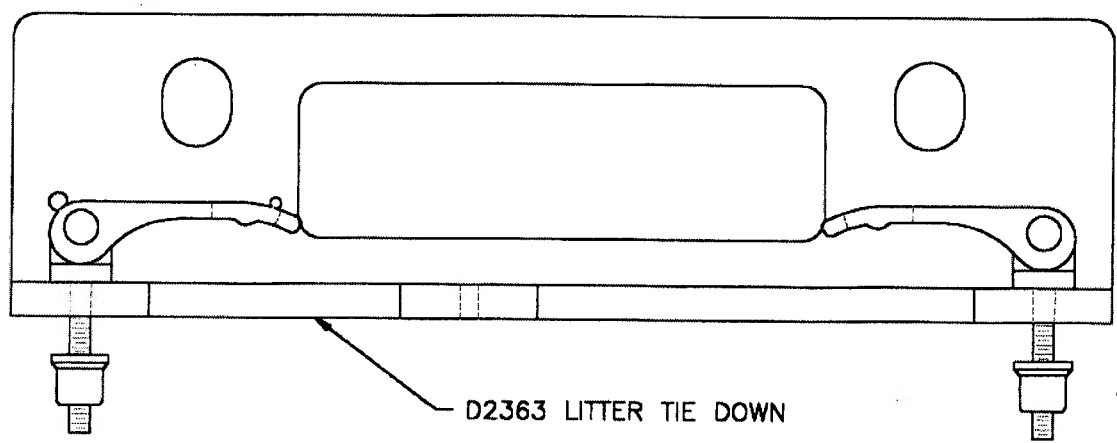
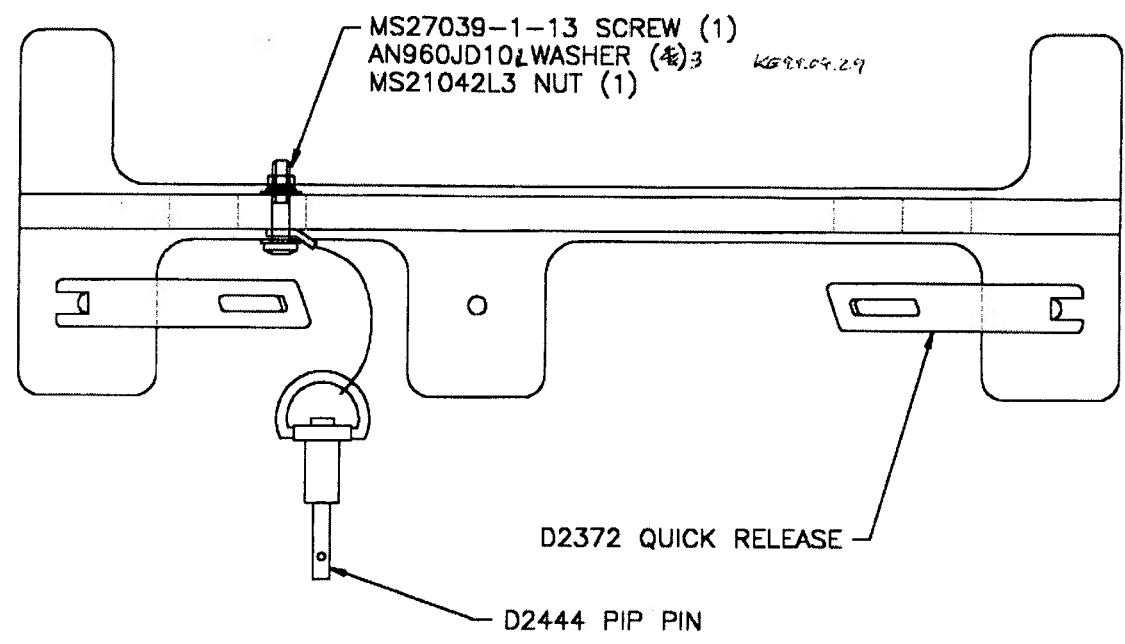
KE 99.04.29

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31883



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED B W	APPROVED <i>[Signature]</i>	D2350	SHEET 2 OF 2
DATE	TITLE	SCALE	
95:02:20	LITTER TIE DOWN ASSEMBLY		

RELEASED
960607



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